

# Work Order ID 59791

Friday, June 11, 2010 12:05:15 PM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 6/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10-6-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

*8/10/06/14*

*H for BG 10/06/14*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*10-6-14 8/14*

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*8/10/06/14*

*(14)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59791**

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Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 6/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 □ Location: _____								
	NEVA								
190		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10/06/15   
MF  
10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 11, 2010 12:05:20 PM

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Work Order ID: 59791

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ AN4-17A	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
			No			160	Each	860.0000	-12	48			

Bolt

## Location

## Loc Qty

## Loc Code

ST359

860

112314

860

D2182B

Manufactured

No

160

f

315.5812

2.5

48  
10 9.4

Rubber Cushion

## Location

## Loc Qty

## Loc Code

ST402A

9.67

30872

9.67

ST410

305.9112

52649

305.9112

Cut qty 6 at 5.00" long

D2274

Manufactured

No

160

Each

591.0000

12

48

Radius Block

## Location

## Loc Qty

## Loc Code

ST010

591

57714

98

57912

273

59108

220

D2432

Manufactured

No

160

Each

0.0000

2

18

206 (24") Bearpaw

59444 10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 59791

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Comments: IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2438		Manufactured	No			160	Each	69.0000	6	24			

S  
M Clamp

10-6-14 40

Location	Loc Qty	Loc Code
ST456	69	

55603

D2529  
S  
M Washer

Manufactured No

160 Each 566.0000

12 48  
10-6-14 SD

Location	Loc Qty	Loc Code
ST017	566	

58568

MS21042L4  
S  
M Nut

Purchased No

160 Each 3,772.000

12 48  
10-6-14 J

(40)

Location	Loc Qty	Loc Code
ST139	2	

111827

ST300

3770

113422

68

114523

694

114718

1000

114784

2000

9063

8

48

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 59791



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
NAS1149D0463J		Purchased	No			160	Each	1,208.000	-24	'96			
Washer													
S M													



10-6-14

SP (C)

## Location

## Loc Qty

## Loc Code

ST298

1208

114576

708

114883

500

96

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

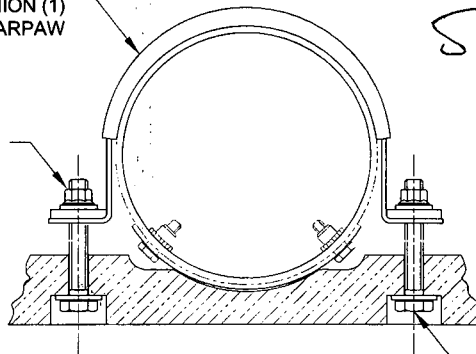
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**REFERENCE ONLY**

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

**Section A-A**  
**Figure 4 – Clamping Detail**

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F

Date: 08.08.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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